

Work Order ID 137568

137568

Page 1

Tuesday, October 06, 2015 1:52:42 PM

Item ID: D2855 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 10/16/2015 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 10/16/2015 Req'd Qty: 50.00 *50* Customer:

Reference:

Approvals: Process Plan: CL Date: OCT 06 2015 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2855	Rev B

100 PURCHASING 0.00
 100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 3008 Cast per Dwg D2855 Material Release Note
 Required
 Supplier: Metallurgie SYCA

CL OCT 06 2015 50

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging Memo 0.02
 Packaging Ensure Material Release Note is attached

54 8015-11-05

120 QC6- Inspect dimensions to drawing 0.00
 120
 QC Memo 0.00
 Quality Control

(54) NOV 06 2015

LAAS
38
9-89

Work Order ID 137568

137568

Page 2

Tuesday, October 06, 2015 1:52:42 PM

Item ID: D2855 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 10/16/2015 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/16/2015 Req'd Qty: 50.00 ***50*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					54	FF		NOV 10 2015
Small Fab	Memo	0.04							
Small Fab	1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr								
140		0.00							DAS 38
140	QC5- Inspect part completeness to step on W/O					54			9-89
QC	Memo	0.02							NOV 10 2015
Quality Control									
150		0.00							DAS 34 9-89
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum					54	φ	15-11-11	
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 2:50 FINISH TIME: 3:00								

Work Order ID 137568***137568***

Page 3

Tuesday, October 06, 2015 1:52:42 PM

Item ID: D2855 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 10/16/2015 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 10/16/2015 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 15 9-89
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>154</u>	<u>4</u>	<u>15/11/12</u>		
170 *170* Small Fab Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.03				<u>154</u>	<u>4</u>	<u>15/11/12</u>		
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>54</u>	<u>4</u>	<u>15-11-12</u>		DAS 34 9-89

Work Order ID 137568***137568***

Page 4

Tuesday, October 06, 2015 1:52:42 PM

Item ID: D2855 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cap
Start Date: 10/16/2015 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 10/16/2015 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00				<u>X54</u>	<u>d</u>	<u>Ill</u>	<u>12/16/12</u>
Packaging	Memo LOCATION : FP001	0.01							
200 *200* QC	QC21- Final Inspection - Work Order Release	0.00				<u>MCS</u>		<u>NOV 12 2015</u>	
Quality Control	Memo	0.08							

MCS NOV 12 2015

Picklist Print

Tuesday, October 06, 2015 1:52:40 PM

Page 1

Work Order ID: 137568

137568

Parent Item: D2855

D2855

Parent Item Name: Cap

Start Date: 10/16/2015

Required Date: 10/16/2015

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225 AELS8-1032-225 Purchased

No

100

Each

146.0000

2

100

108

AI S7-1032-225

Insert

**

all 10/16/15

ALS4 1032-225

Location

Loc Qty

Loc Code

FG

120

118520

120

11131502

X108

FP001

26

m131657

26

D2855P

Purchased

No

170

Each

0.0000

1

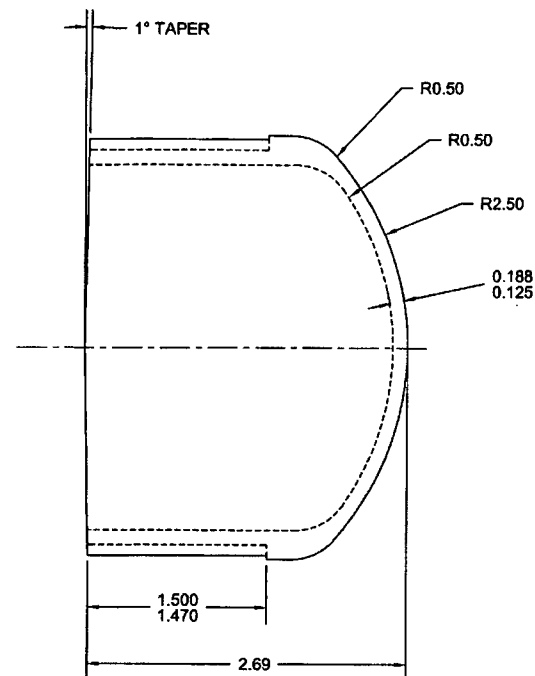
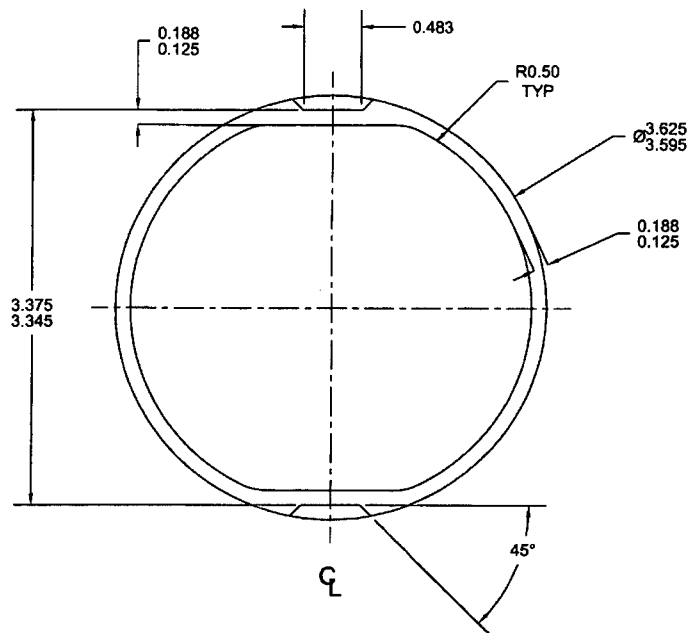
50

D2855P

Cap

**

5/11/15 10/16/15



D2855C CASTING DETAIL



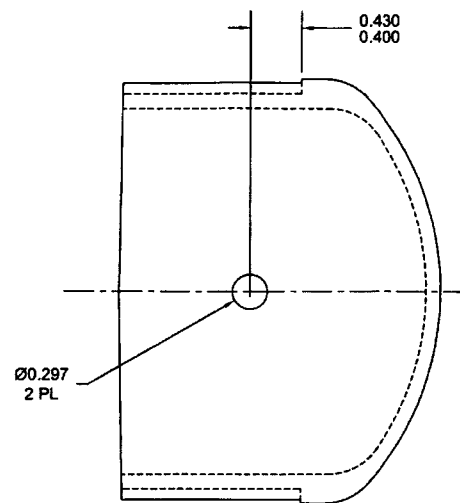
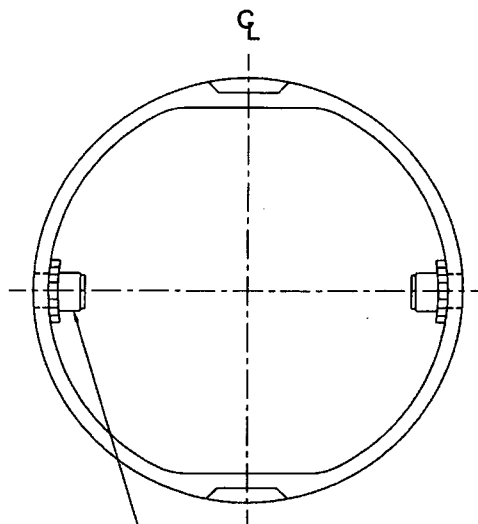
RELEASED
09/15/15

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

C/L 15/10/06
W/0: 137568

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

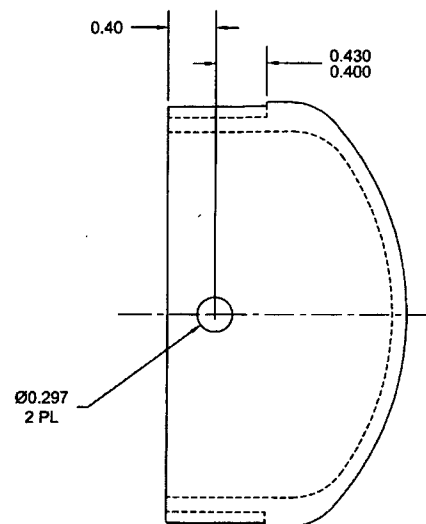
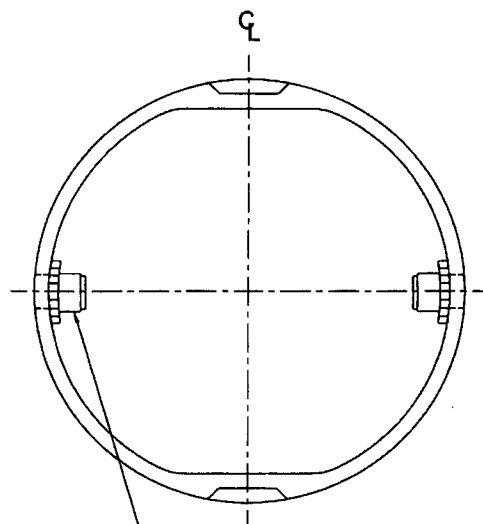
D2855 CAP (MAKE FROM D2855C CASTING)

RELEASED
21/5/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POKER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
2017/10/10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30018**

Purchase Order Date 10/5/2015 3:14:53 PM

PO Print Date 10/6/2015

Page Number 1 of 2

Order From :

VC-MSY01

Ship To : DART AEROSPACE LTD

METALLURGIE SYCA
500 PRINCIPALE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ST.DOMINIQUE, QUEBEC JOH 1LO

Contact Name

Vendor Phone

450-261-0853

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

FedEx Overnight collect

FOB

EXW - (Ex Works)

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B B137525	Cap	10/23/2015 Yes 10/23/2015		50.00 Each	\$14.25	\$712.50

Line Total: \$712.50

5	D2855P AS PER DWG D2855 REV. B B137568	Cap	10/23/2015 Yes 10/23/2015		50.00 Each	\$14.25	\$712.50
---	--	-----	---------------------------------	--	---------------	---------	----------

Line Total: \$712.50

PO Instructions: Fedex Acc#151793240

Note:

10/6/2015

METALLURGIE SYCATINC
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE 30018
ORDER NO.

DATE

4-11-2015

VENDU À DART AEROSPACE LTD.
SOLD TO

ADRESSE 1270, ABERDEEN STREET
ADDRESS

EXPÉDIÉ À HAWKSBURY, ONT.
SHIP TO

ADRESSE KGA-1K7
ADDRESS

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDUEUR
SALES PERSON

104

D-2855

54X

1 BOX x 60 Pcs x 32 POUNDS ✓

1 BOX x 44 Pcs x 24 POUNDS ✓

2015-11-05

TRANSPORT FEDEX

THANKS FOR YOUR SUPPORT

TOTAL

546001

SIGNATURE

Blueline DCB27

FORMULAIRE DE VENTE - SALES ORDER ©Blueline®, 2010